DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES Office of Structural Materials

Quality Assurance and Source Inspection

Bay Area Branch 690 Walnut Ave.St. 150 Vallejo, CA 94592-1133 (707) 649-5453

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Contract #: 04-0120F4

Cty: SF/ALA Rte: 80 PM: 13.2/13.9

File #: 69.28

WELDING INSPECTION REPORT

Resident Engineer: Siegenthaler, Peter **Report No:** WIR-021955 Address: 333 Burma Road **Date Inspected:** 18-Mar-2011

City: Oakland, CA 94607

Project Name: SAS Superstructure **OSM Arrival Time:** 1500 **OSM Departure Time:** 300 **Prime Contractor:** American Bridge/Fluor Enterprises, a JV

Contractor: Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** ShangHai, China

CWI Name: Sha Zhi **CWI Present:** Yes No **Inspected CWI report:** Yes N/A **Rod Oven in Use:** Yes No No N/A N/A **Electrode to specification:** Yes No **Weld Procedures Followed:** Yes No N/A N/A **Qualified Welders:** Yes No **Verified Joint Fit-up:** Yes No N/A N/A Yes N/A **Approved Drawings:** Yes No **Approved WPS:** No Yes No N/A **Delayed / Cancelled:**

34-0006 **Bridge No: Component:** OBG

Summary of Items Observed:

Summary of Items Observed: On this date Caltrans OSM Quality Assurance(QA) Inspector, DJ Shin was present during the times noted above for observations relative to the work being performed.

Bay 1

Heat straightening of PCMK, 20TR2-037, under approved Heat Straightening procedure, HSR (B)-461, The in process temperature was at the time of this observation witnessed at less than 600°C. The ZPMC QC was identified as Tian Lei. The approved HSR procedure stated that a maximum temperature of 650°C with 1-3 applications. The distortion that was previously measured and recorded on the HSR was Maximum 80mm.

Bay 8

This QA Inspector observed the following work in progress for Bay 8.

ZPMC was using the Flux Core Arc Welding (FCAW) process.

ZPMC QC is identified as Liu Chuan Gang.

Welding variables recorded by QC appeared to comply with the approved Welding Procedure Specifications (WPS). Listed below are the locations that were identified by this QA inspector.

Components: Bike Path

PCMK: BK004A5-062-110,111,113,114

Welder: 054459

WPS-B-P-2213-TC-U4b-FCM-1

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Bay 10

This QA Inspector observed the following work in progress for Bay 10.

ZPMC was using the Flux Core Arc Welding (FCAW) process.

ZPMC QC is identified as Liu Sun Zi Wang.

Welding variables recorded by QC appeared to comply with the approved Welding Procedure Specifications (WPS). Listed below are the locations that were identified by this QA inspector.

Components: Bike Path PCMK: BK010A1-001-043

Welder: 040302

WPS-B-T-2232-ESAB

PCMK: BK3001-001-004

Welder: 040365

WPS-B-T-2231-ESAB

PCMK: BK17B-001-017

Welder: 057266

WPS-B-T-2231-ESAB

PCMK: BK3001-001-051

Welder: 040367

WPS-B-T-2233-ESAB

This QA Inspector observed the following work in progress for Bay 10.

ZPMC was using the Shield Metal Arc Welding (SMAW) process.

ZPMC QC is identified as Sun Zi Wang.

Welding variables recorded by QC appeared to comply with the approved Welding Procedure Specification (WPS).

Listed below are the locations that were identified by this QA inspector

Components: Bike Path PCMK: BK010A1-001-044 Welder: 056364, 057258 WPS-B-P-2211-B-U2

PCMK: BK17B-001-013

Welder: 040581

WPS-B-P-2213-TC-U4C

This QA Inspector observed the following work in progress for Bay 10.

ZPMC was using the Submerged Arc Welding (SAW) process.

ZPMC QC is identified as Sun Zi Wang.

Welding variables recorded by QC appeared to comply with the approved Welding Procedure Specification (WPS).

Listed below are the locations that were identified by this QA inspector

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Components: Bike Path PCMK: BK15B-001-004

Welder: 050295

WPS-B-T-2221-TC-U4a-S

Trial Assembly Yard

This QA Inspector observed the following work in progress for Trial Assembly Yard.

ZPMC was using the Shield Metal Arc Welding (SMAW) process.

ZPMC QC is identified as Zhu Zhong Hai.

Welding variables recorded by QC appeared to comply with the approved Welding Procedure Specification (WPS).

Listed below are the locations that were identified by this QA inspector

Components: 13AE PCMK: SEG3007A-007

Welder: 067610

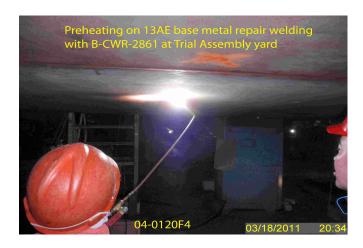
WPS-B-P-2214-B-U2-FCM

PCMK: Base Metal repair support jig remove area

Welder: 200113 Report: B-CWR-2861

WPS-345-SMAW-4G (4F)-FCM-repair

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.



Summary of Conversations:

No relevant conversations

Comments

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This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang 15000422372, who represents the Office of Structural Materials for your project.

Inspected By:	Shin,DJ	Quality Assurance Inspector
Reviewed By:	Riley,Ken	QA Reviewer